

5228933



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6207

Job Sheet 201630



Part No: D6207
Part Name: Angle Extrusion

Job Qty: 20 pcs

NOV 01 2019

DAS
13
9-89

Part Weight: 0 lbs
Job Created: 10/8/19
Due Date: 10/18/19

Type: Stock

Note: DWG REV A

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Chantal Lavoie

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft OCT 18 2019	20 ft		10/18/19	0.00	0.00	Purchasing - 1	DAS	
							Purchasing - 2	81	
							Purchasing - 3	9-89	NOV 01 2019
110	Packaging 2-1 - Receive - B4B	20 pcs		10/18/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B	DAS 81	NOV 01 2019
							Packaging 2 - 19 - B4B	9-89	
							Packaging 2 - 20 -		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S228933



Part: D6207
Job No: 201630
Serial No/Batch: S228933

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 11/01/19

Plex 10/8/19 8:01 AM Dart.Lavoie.Chantal

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 6	20 pcs	10/18/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
130	Packaging 3-1 - Stock - B4B	20 pcs	10/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B

Plex 10/8/19 8:01 AM Dart.Lavoie.Chantal

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	20 pcs	10/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Purchasing) Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs) 120 - (QC6- All purchased or subcontracted products) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6207P	Angle Extrusion 1X1X.125	20 ft (1 ea)	100-Purchasing - Ft	5285340 vm.	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Purchasing - Ft	D6207P	20	0	0	
Part Specifications					
Specifications could not be found.					

Plex 10/8/19 8:01 AM Dart.Lavoie.Chantal

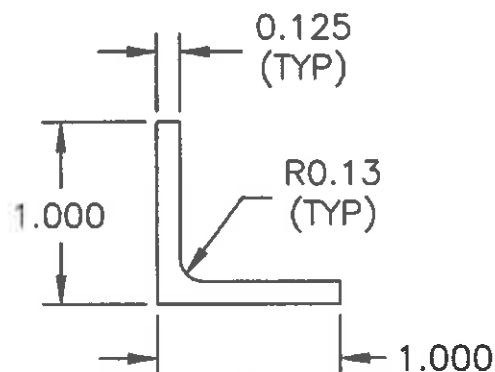


DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED
02.03.13

SPECIFICATION CONTROL DRAWING

Line 3
D6207



D6207-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.000" x 1.000" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044819**



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044819

PO Date: 10/18/19

Due Date: 10/25/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

OCT 18 2019

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: quote no. sou0217245

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M304S12GA			304/316 0.100" Sheet : MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed	-	10/25/19	32 sf	32 sf Vm	32 sf	\$12.549062/sf	\$401.57
												OCT 22 2019	
2		M304R1.000			304 Round Bar 1.00 : MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed	-	10/25/19	24 ft	27.5 ft Vm	24 ft	\$8.3025/ft	\$199.26
												OCT 22 2019	
3	201630	D6207P			Angle Extrusion 1X1X.125 MATERIAL: 6061T6 ANGLE 1" X 1" X .125" WALL AS PER 6061-T6 / T6511 (QQ-A-200/8)	Firmed	-	10/25/19	.916 ft	1.0 ft Vm	1 ft	\$40.00/ft	\$36.64
												OCT 22 2019	
4		M6061T6B0.500X12.000			6061-T6 Bar .500 X 12.00 : MATERIAL: 6061- T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ- A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ- A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 receive ft	Firmed	-	10/25/19	12 ft	12 ft Vm	12 ft	\$24.701333/ft	\$296.42
												OCT 22 2019	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044819



Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5		M6061T6B2.000X02.000			6061-T6 Bar 2.00 X 2.00 : MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 receive ft	Firmed	-	10/25/19	12 ft	12 ft	12 ft	\$15.288333/ft	\$183.46
										12 ft VM		OCT 22 2019	
6		M6061T6B1.000X02.000			6061-T6 Bar 1.00 X 2.00 : MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 receive ft	Firmed	-	10/25/19	60 ft	60 ft	60 ft	\$7.3428333/ft	\$440.57
										60 ft VM		OCT 22 2019	
7		M6061T6B1.500X1.500			6061-T6 Bar 1.50 X 1.50 : MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 receive ft	Firmed	-	10/25/19	20 ft	20 ft	20 ft	\$8.0985/ft	\$161.97
										20 ft VM		OCT 22 2019	
8		M6061T6S.250			6061T6 Sheet .250 : MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 receive sf	Firmed	-	10/25/19	32 sf	32 sf	32 sf	\$18.30375/sf	\$585.72
										32 sf VM		OCT 22 2019	
9		M304B0.250X4.000			304 Bar .250 X 4.00 : MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed	-	10/25/19	24 ft	24 ft	24 ft	\$10.7425/ft	\$257.82
										24 ft VM		OCT 22 2019	

Grand Total: \$2,563.43



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044819



Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/18/19 2:01 PM Dart.Lavoie.Chantal



ACIER OUELLETTE INC.

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT

Copy

CO00174958

Billed to

DART AEROSPACE LTD

1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att :

Instruction

F-M

Delivery Route

5

Customer N°

CLI0001056

Date

2019/10/18

Delivery date

2019/10/22

Your order N°

POHB044819

Processed by

Josianne Bourdon

Salesman

JOSIANNE BOURDON

Carrier

OUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only			
				CMD	EXP	B/O	IN	I	S	C
1 FLAT ALU 1/2 X 12 6061-T6 * FAL-1212 7447 1 X 12' POHB044819 LINE 4 HEAT: 43380 VM	84.70	12.00	PI_\$CLB		12'	VM				
2 SQUARE ALU 6061-T6 2 * CAL-2 1785 1 X 12' POHB044819 LINE 5 HEAT: 43998 VM	56.45	12.00	PI_\$CLB		12'	VM				
3 FLAT ALU 1 X 2 6061-T6 * FAL-12 2497 3 X 20' POHB044819 LINE 6 HEAT: 50D181531 VM	144.00	60.00	PI_\$CLB		2x 20'	VM				
4 SQUARE ALU 6061-T6 1 1/2 * CAL-112 1773 1 X 20' POHB044819 LINE 7 HEAT: 5XE181120 VM	52.94	20.00	PI_\$CLB		1x 20'	VM				
5 ALU PLATE 1/4 6061-T651 (4 X 8) PAL-14486061 4242 1 X 4' X 8' POHB044819 LINE 8 LOT: 712733B5 CAST: 335 VM	117.12	32.00	PI2_\$CLB		1x 20'	VM				



DELIVERY - CLIENT

CO00174958

Copy

Product Description	Qty	Weight	UM	PCS NB				Internal Use Only			
				CMD	EXP	B/O	IN	I	S	C	OUT
PACKAGING		1.00	UN								
6 SHEET SS 12G SS304-2B (4 X 8) FESS-12G483042B 3407 1 X 4' X 8' POHB044819 LINE 1 HEAT: 12513A06 <i>vm</i>	147.01	32.00	PI2_\$CLB								
PACKAGING		1.00	UN								
7 ROUND SS 304 1 (R) 5747 RSS-1 2 X 12' R/L POHB044819 LINE 2 HEAT: FF-6433 <i>vm</i>	64.08	24.00	PI_\$CLB								
8 ANGLE ALU 1 X 1 X 1/8 R 6061-T6 * AAL-1118 1301 2 X 20' POHB044819 LINE 4 HEAT: SXE190022 <i>vm</i>	11.24	40.00	PI_\$CLB								
9 FLAT SS304 1/4 X 4 (R) 3522 FSS-144 2 X 12' R/L POHB044819 LINE 9 HEAT: 524305 <i>vm</i>	81.60	24.00	PI_\$CLB								
Note : ATTENTION: MILL TEST REQUIS Chaque item identifier avec : - Le # PO client - Le # d'item - Le heat # - Emballer les pièces dans carton											



DELIVERY - CLIENT

Copy

CO00174958

Product Description	Qty	Weight	UM	PCS NB			Internal Use Only					
				CMD	EXP	B/O	IN	I	S	C	OUT	
Total Weight (Lbs) : 759.14				NIR : R-109516-6								
Conditions : All sold and delivered materials remain the property of "Acer Ouellette Inc." until payment is made in full, complete and cashed. All lost materials are at the buyer's expense. The warranty offered by "Acer Ouellette Inc." is the same as offered and honored by the manufacturer and his warranty is transferred by "Acer Ouellette Inc." to the client. The buyer hereby accepts to respect the following conditions: Net 30 days from billing date and the buyer accepts to pay administration charges of 2% per month (24% per annum) on all past due amounts over 30 days. Any default in respect with this contract will lead to payment by acceleration and permits to the seller, at his choice to claim for the balance due or the repossession of the goods sold. All claims must be made within five (5) days with this document enclosed. Any merchandise that has been damaged, cut or modified cannot be returned. All goods returned must be with our authorization and are subject to a 25% restocking charge.												
Prepared By : 	Verified By : 	Delivered By :	Time	Y M D			Date					
Customer's Signature												



Global Vietnam
Aluminium Co., Ltd

GLOBAL VIETNAM ALUMINIUM COMPANY LIMITED

Address: MY XUAN BI-CONAC INDUSTRIAL ZONE, MY XUAN WARD, PHU MY TOWN,
BA RIA-VUNG TAU PROVINCE, VIETNAM

Tel: +84(0)643924954

Fax: +84(0)643924953

MILL TEST CERTIFICATE

Date: January 29th, 2019

PO number: SR-PO0000100

Shipping Ref No.: 19-0200

LC No.: DC.HMN910274

Date of issue: January 24, 2019

Item Code: BX090035

Die Number: D00580

Alloy & Temper: 6061-T6

Production Description: ALUMINIUM EXTRUDED PROFILES

ALU ANGLE 6061-T6 1" x 1" x 1/8" 20'

Length (inch): 240

Bundle number: SR-PO0000100-017

Heat Number: SXE190022

Date: 09/01/2019

Applicable Specifications: ASTM B221 STANDARDS

CHEMICAL ANALYSIS: %

Si	Mg	Fe	Cu	Mn	Cr	Zn	Ti	Al	Other		Remark:
									EACH	TOTAL	
0.655	0.981	0.220	0.261	0.013	0.037	0.987	0.017	97.613	<0.05	<0.10	06/01/2019

MECHANICAL ANALYSIS:

Ult. Strength (ksi)	Yield Strength (ksi)	Elongation % IN 2"	Remark:
45.82	41.44	13.20	06/01/2019

All profiles, showing material shipped match aluminium alloy as per standard, with chemical analysis to match aluminium alloy standard.

We hereby certify that the item listed have been checked and tested in accordance with the specifications noted and have been found to meet all the applicable requirements. Certifications are kept on file for 36 months from the date of purchase and are available for review upon request, referring to ASTM and the PO number.

Quality Manager



TRUNG TÂM KIỂM NGHIỆM CÔNG TY
THÀNH NHÓM TOÀN CẦU VIỆT NAM
GLOBAL VIETNAM ALUMINIUM
CO., LTD TESTING CENTER

H: SXE 190022

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6207
DATE: OCT 25 2019

PO / BATCH NO.: POHBO44819/5225340

MATERIAL CERT REC'D: YKS
QUANTITY RECEIVED: 40 #
QUANTITY INSPECTED: 10 #
QUANTITY REJECTED:

THICKNESS ORDERED: .125"
THICKNESS RECEIVED: .125"
SHEET SIZE ORDERED:
SHEET SIZE RECEIVED:

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y <u>N</u>	
CORRECT FINISH	Y <u>N</u>	
CORROSION	Y <u>N</u>	
CORRECT GRAIN DIRECTION	Y <u>N</u>	
CORRECT MATERIAL PER M-DRAWING	Y <u>N</u>	ASTM B221
CORRECT THICKNESS	Y <u>N</u>	
PHOTO REQUIRED	Y <u>N</u>	
CORRECT REF # TO LINK CERT	Y <u>N</u>	HT: SXE190022
CORRECT MATERIAL IDENTIFICATION	Y <u>N</u>	
CORRECT M# ON THE MATERIAL	Y <u>N</u>	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y <u>N</u>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y <u>N</u>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: _____	DAS 81 9-89	SIGNED OFF BY: <u>q</u>	
DATE: <u>OCT 25 2019</u>		DATE: <u>10/31</u>	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in